



Dart Aerospace Ltd.
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D4854-7
Job Sheet 170115



Part No: D4854-7

Job Qty: 10 ea

Part Name: Lower Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4854 REV.B IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.08 AS PER DWG REV.B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/25/18	0.00	0.00	Start Up Waterjet		OK 18/01/14
100	Waterjet	10 pcs		1/25/18	0.00	2.50	Waterjet1		OK 18/01/14
105	QC	10 pcs		1/25/18	0.00	0.00	QC2 Waterjet-1		OK 18/01/14
110	Mill Conv	10 pcs		1/25/18	0.00	9.90	Mill Conv 1		OK 18/01/14
130	QC	10 pcs		1/25/18	0.00	0.00	QC8		OK 18/01/23
140	HandFinish	10 pcs		1/25/18	0.00	0.19	HandFinish1		OK 18/01/23
150	QC	10 pcs		1/25/18	0.00	0.00	QC7-4		OK 18/01/23
160	Powdercoat	10 pcs		1/26/18	0.00	0.50	Powdercoat1		OK 18/01/23
170	QC	10 pcs		1/26/18	0.00	0.00	QC3		OK 18/01/23
180	Packaging	10 pcs		1/26/18	0.00	0.00	Packaging3-2	57526	OK 18/01/23
190	QC21-SA	10 Ea		1/26/18	0.00	0.00	QC21		OK 18/01/23

Part Op 100 - CUT AS PER FILE DWG REV: B PROG REV: B DEBURR

Descriptions: 110 - MILL RADS DRILL HOLES AS PER DWG DEBURR OPEN SLOT TO .260" AS PER DWG

160 - ***MASK AS PER DWG *** START TIME: 3:35 OVEN TEMPERATURE: 300 FINISH TIME:

4:05 M 138467

Job Allocations

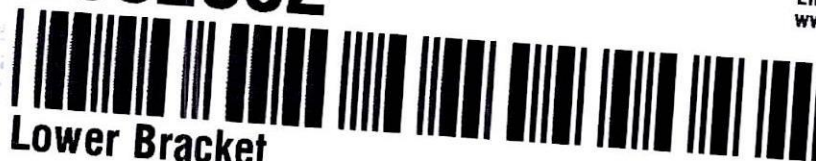
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X04.000	4	32	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Bracket	0.300Inches ± 0.030	0.330 0.270		
2	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
3	Lower Bracket	2.200Inches ± 0.030	2.230 2.170		
4	Lower Bracket	2.280Inches ± 0.030	2.310 2.250		
5	Lower Bracket	3.550Inches ± 0.030	3.580 3.520		
6	Lower Bracket	4.550Inches ± 0.030	4.580		

DART
AEROSPACE

S032582



Lower Bracket

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CANADA

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PART NO: D4854 - 7

Original Serial #: S032582

Revision:

Operation:

Change No:

Start up Operation 01/16/18

Job No: 170115

			4.520	
7	Lower Bracket	0.260Inches ± 0.030	0.290 0.230	
8	Lower Bracket	0.750Inches ± 0.030	0.780 0.720	
9	Lower Bracket	0.257Inches $+ 0.005$ $- 0.000$	0.262 0.257	Diameter
10	Lower Bracket	3.800Inches ± 0.005	3.805 3.795	
11	Lower Bracket	1.930Inches ± 0.030	1.960 1.900	
12	Lower Bracket	1.250Inches ± 0.010	1.260 1.240	
13	Lower Bracket	0.380Inches ± 0.030	0.410 0.350	Radius

Plex 1/10/18 12:28 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					